

Date: Tuesday, 12/20/2005 3:37:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SKITUBE WEB
Job Number : 25331	
Estimate Number : 10498	
P.O. Number :	Part Number : D2739
This Issue : 12/20/2005 S.O. No. :	Drawing Number : D2739 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 12/20/2005 Type : LANDING GEAR	Drawing Revision : B
Previous Run : 24671	Material :
Written By :	Due Date : 1/15/2006 Qty: 8 Um: Each
Checked & Approved By :	
Comment : Est. C 02.11.28 Reformat KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Extrusion 'I Beam' thin

Pick:

Qty Part Number Description Batch

1 D2600-5 Web *B 24410 A.m 06-01-05*

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739 *A.m 06-01-05*

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 *A.m 06-01-05*

3-Use uni-bit to open holes to finish size as per Dwg D2739. *A.m 06-01-05*

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends. *06-01-05 A.m*

5-Use a red or black lead-free paint pen to write the part number and batch number in the middle of each *A.m 06-01-05* web. *8*

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

A.m 06-01-06

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

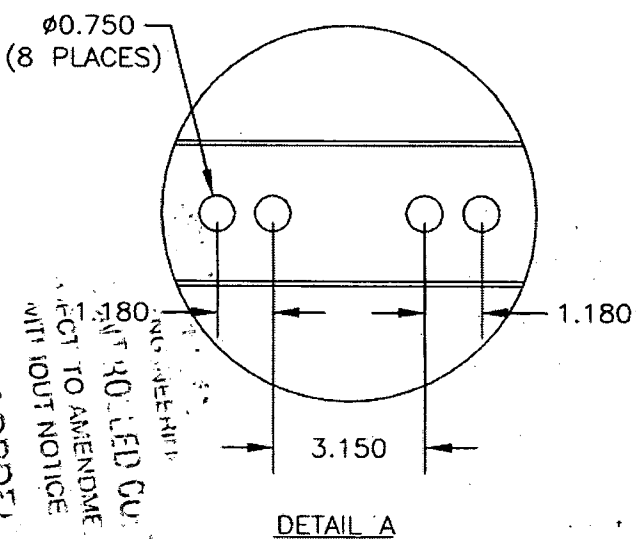
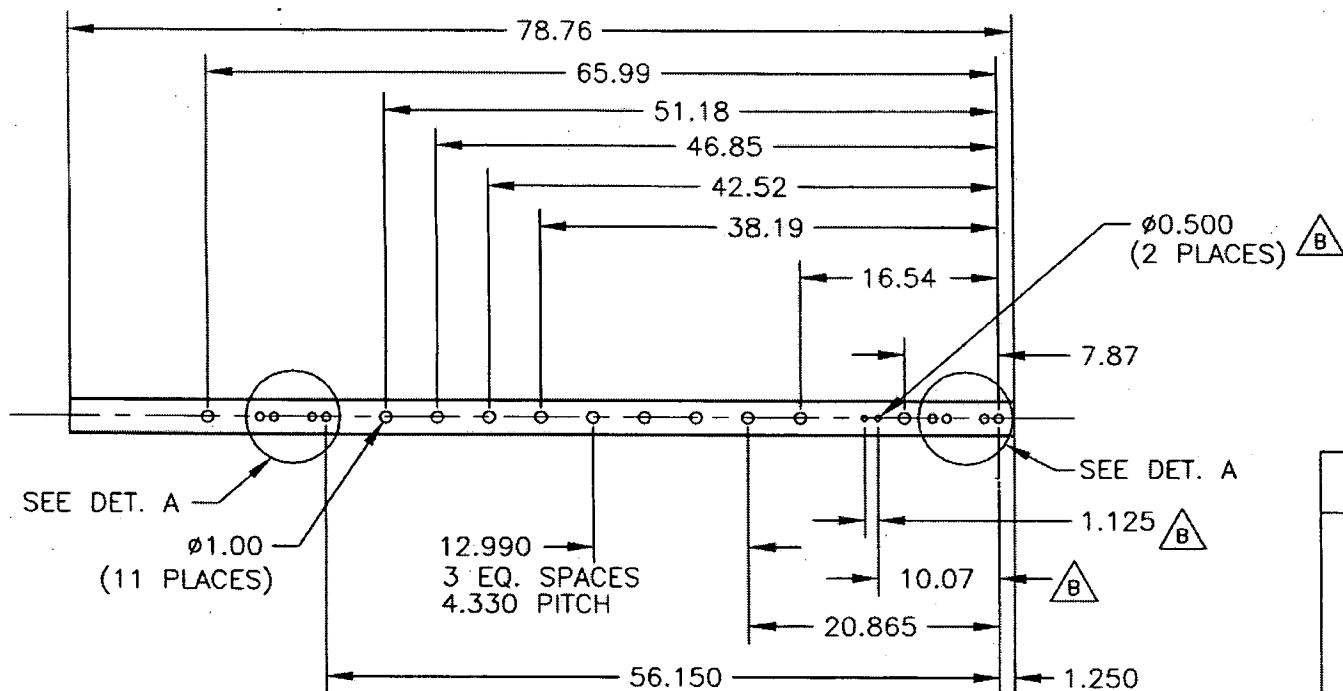
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
12/1	12/1	BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO.
12/1	12/1	D2739
DATE	TITLE	SHEET 1 OF 1
98.11.18	WEB	SCALE
		1:15
A	98.04.16	NEW ISSUE
B	98.11.18	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS



MAKE FROM D2600-5 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

RELEASED
98.12.16 DS

